

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024115**Date Inspected:** 14-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Trial Assembly

This QA inspector performed a random observation for the OBG 13AE. During the observation performed it was noted ZPMC was in process of welding segment welds. ZPMC QC inspector Wang Li Yang was present at this time of this observation and informed this QA inspector of the work that is in process and identified Zhu Zhong Hai as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

13AE (WR20962)

Weld- RS3112A (I-rib)

WPS-485-SMAW-3G(3F)-Repair

Welder- 044504

SMAW/Base Metal Build-up Weld

MT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) NWIT #09132 Item 1 & 2 on OBG 13AE assembly. This QA Inspector performed Visual Inspection (VT) and Magnetic Particle Testing (MT) inspection after ZPMC had performed their MT inspection of the following locations;

WELDING INSPECTION REPORT

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SEG3007C-506, *507, 508, *509, 238, 239, 240, 241, 242, 243, 311, *312, 313, 300, *301, 302, 303, *304, 305, *306, 307, *308

SEG3007E-237, 238, 239, 249, 250, 251, 252

KP3005-008~015

*Welds identified with an asterisk weld canceled by ZPMC QC inspector Xie Ming Feng for not being ready for QAMT.

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Magnetic Particle Test Report (TL6028), dated 05-14-2011 for additional information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
